

Work Order ID 68632

Tuesday, April 19, 2011 11:53:42 AM

Page 1

Item ID: D2894-1

Revision ID:

Item Name: 2.750 Support

Start Date: 4/19/2011 Start Qty: 6.00

Required Date: 4/25/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 4-04-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2894

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA253
Tumble & Deburr

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

120

0.00



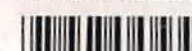
QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control



11.7.29

3

11.7.29

3

11/07/29

3

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68632

Page 2

Tuesday, April 19, 2011 11:53:42 AM

Item ID: D2894-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.750 Support

Start Date: 4/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

HAND FINISHING RESOURCE #1

Mask and prime inside surface as per dwg D2894 per Dart QSI 005 4.2

RT

11-07-30

170

0.00



QC14- Inspect Spray Paint

QC

Memo

0.00

Quality Control

B

11-08-02

180

0.00

Identify as per dwg & Stock Location: *+ inside*

Packaging

Memo

0.00

Packaging

RT

11-08-02

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Tuesday, April 19, 2011 11:53:42 AM

Page 3

Item ID: D2894-1

Accept

Revision ID:

Item Name: 2.750 Support

Start Date: 4/19/2011 Start Qty: 6.00

Required Date: 4/25/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/03

M11-08-21

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Picklist Print

Tuesday, April 19, 2011 11:53:49 AM

Page 1

Work Order ID: 68632



Parent Item: D2894-1



Parent Item Name: 2.750 Support

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 02.11.26 Added mask hole KJ
IPP Rev: C ECN 993 07-11-07 DD verified by: EC
IPP D 08.03.19 Re-format EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK079

Manufactured No

Each 7.0000

3



D2894-1 TURNING DETAIL

129 11.7.29

Location

Loc Qty

Loc Code

MAT060

7

43976 ✓

7

3

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DART AEROSPACE LTD		Work Order:	49632
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.466	.466	.466		
AB	3.062	3.082		3.072	3.072	3.072		
AC	0.053	0.073		.063	.063	.063		
AD	1.766	1.786		1.767	1.767	1.771		
AE	0.020	0.040		.030	.030	.03		
AF	0.260	0.267		.262	.262	.262		
AG	0.170	0.190		.180	.180	.180		
AH	0.150	0.170		.160	.160	.160		
AI	1.990	2.010		2.000	2.000	2.000		
AJ	0.240	0.260		.250	.250	.250		
AK	1.880	1.900		1.898	1.890	1.890		
AL	0.500	0.505		.500	.500	.500		
AM	0.188	0.194		.188	.188	.188		
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by: RP	11.7.29	Date: 11.7.29
Audited by: ATG		Date: 11/07/29
Prototype Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	

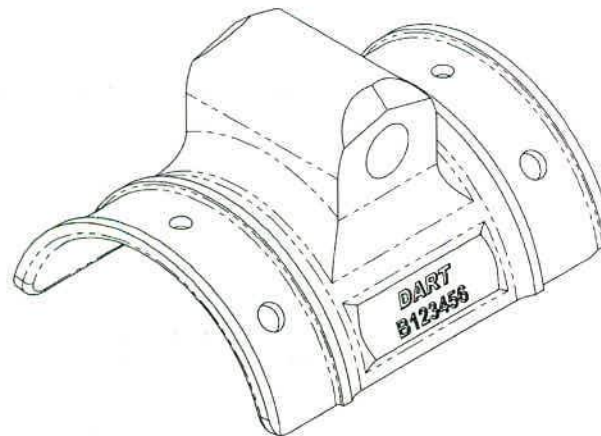
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D2894-1 Ø2.750 SUPPORT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68632

PH-0419

RELEASED
8/11/09

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs



D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84. B5-2 0.261 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
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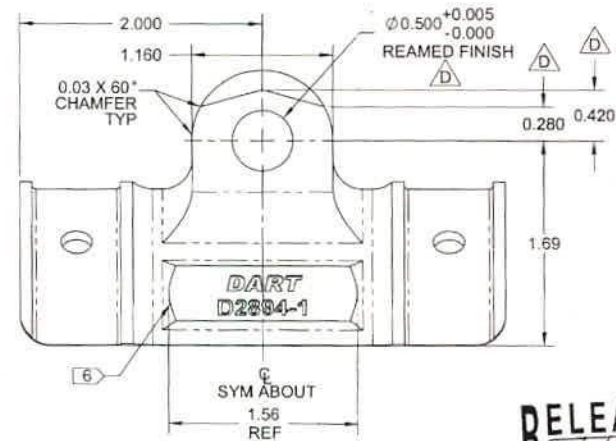
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D2894-1 Ø2.750 SUPPORT

RELEASE
2011/19 NY

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2894	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
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